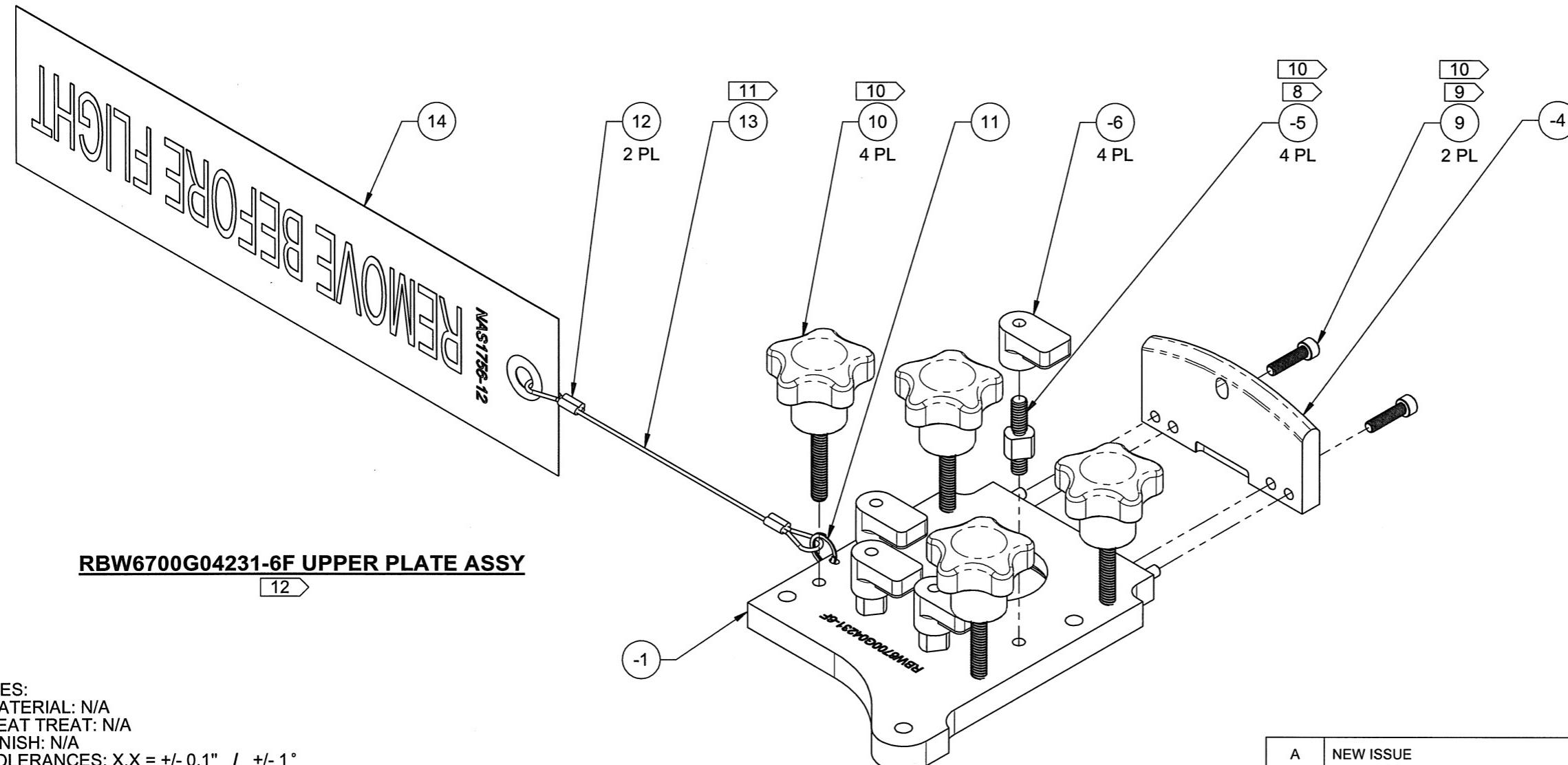
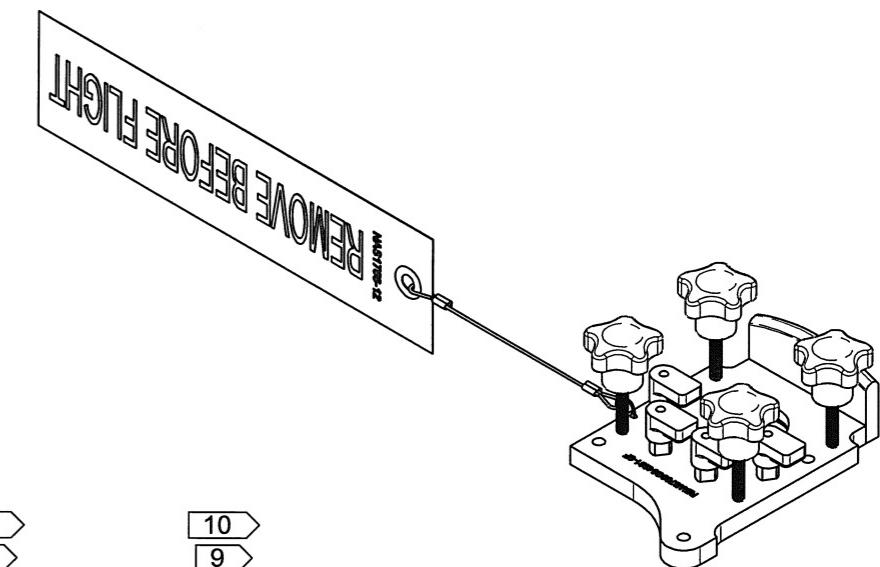


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6700G04231-6F-1	PLATE ASSY
-4	1	RBW6700G04231-6F-4	BRONZE PLATE
-5	4	RBW6700G04231-6F-5	SHAFT
-6	4	RBW6700G04231-6F-6	STOPPER ASSY
9	2	McMaster#91251A345 OR EQUIV	STEEL BLACK OXIDE SOCKET HEAD SCREW #10-32 x 3/4" LG.
10	4	McMaster#59625K420 OR EQUIV	FIVE ARM KNOB 1/4"-20 X 1 1/2" STUD LENGTH
11	1	McMaster#90177A213 OR EQUIV	ZINC PLATED STEEL SPLIT RING 9/16" OD x 7/16" ID. x 1/16" THK
12	2	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
13	AR	CARR LANE#CL-2-C	STEEL NYLON COATED 1/16" DIA. LANYARD
14	1	NAS1756-12	REMOVE BEFORE FLIGHT FLAG



RBW6700G04231-6F UPPER PLATE ASSY

NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) APPLY RED THREADLOCKER LOCTITE 263/262 ONLY ON THREADS OF ITEMS -5 THAT IS ASSEMBLE WITH ITEM -1, AND REMOVE EXCESS
 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEMS 9 THEN ASSEMBLE WITH ITEMS -4 & -1, AND REMOVE EXCESS
 10) INSTALL ITEMS -5, 9 & 10 HAND TIGHT
 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1"
 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-676	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	REV. A	
MFG. APPR.	FK	SHEET 1 OF 9	
APPROVED	VIP	SCALE	
DATE 4/2/2019		NTS	
TOOL PART # RBW6700G04231-6F			
TITLE UPPER PLATE ASSY			
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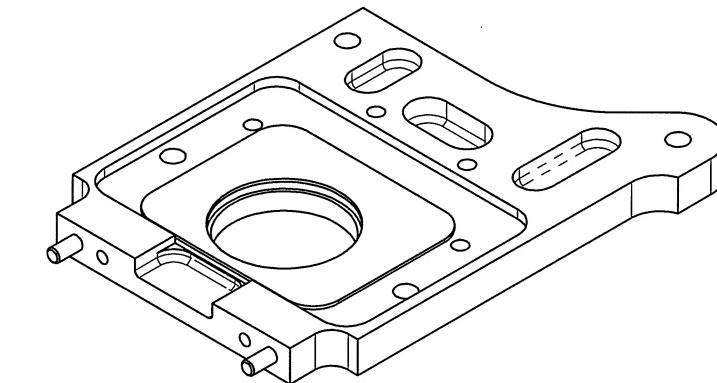
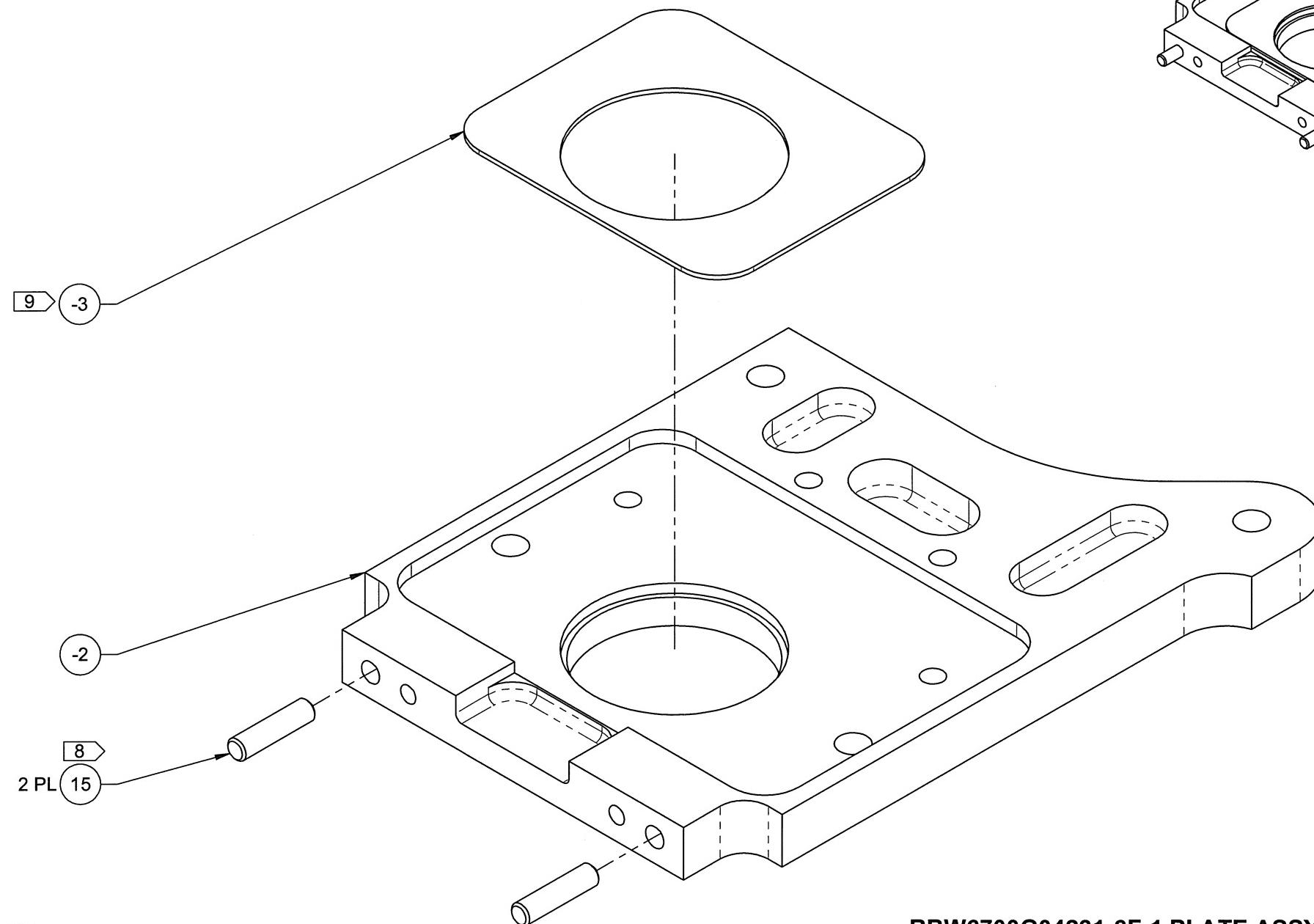
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6700G04231-6F-2	PLATE
-3	1	RBW6700G04231-6F-3	PLATE PROTECTION
15	2	McMaster#98381A316 OR EQUIV	STEEL BLACK OXIDE DOWEL PIN 3/16" DIA. x 3/4" LG.

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NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES

THEN PRESS FIT ITEMS 15 WITH ITEM -2 UNTIL BOTTOMED OUT, AND REMOVE EXCESS

9) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -3 AND ITEM -2, REMOVE EXCESS, AND CUT EXCESS IF NECESSARY

RBW6700G04231-6F-1 PLATE ASSY

DESIGN DRAWN	VM VM	DART AEROSPACE LTD
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	FK	TOOL PART #
APPROVED	WP	RBW6700G04231-6F
DATE 4/2/2019		TITLE
		UPPER PLATE ASSY
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REV. A
SHEET 2 OF 9
SCALE NTS

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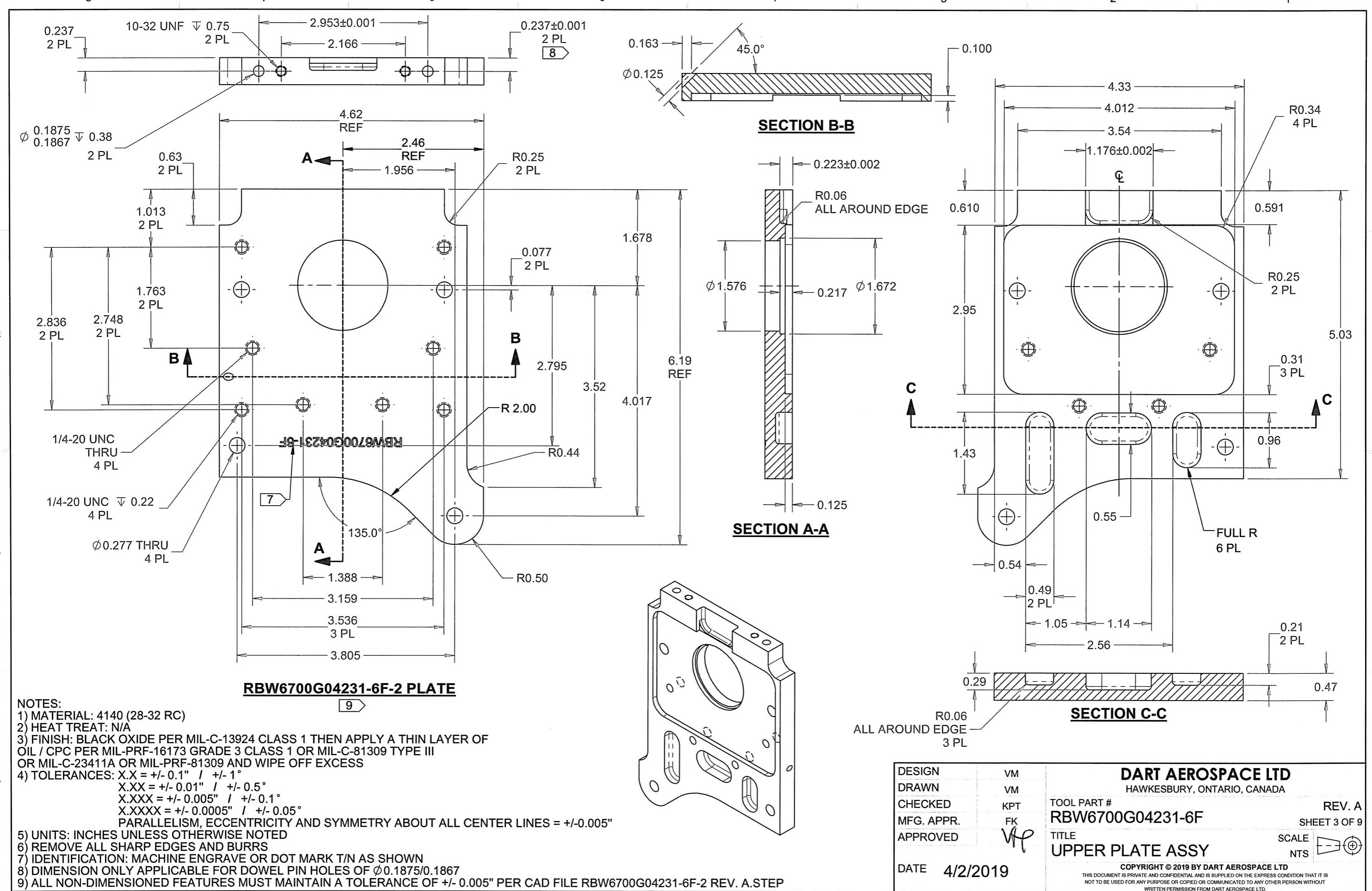
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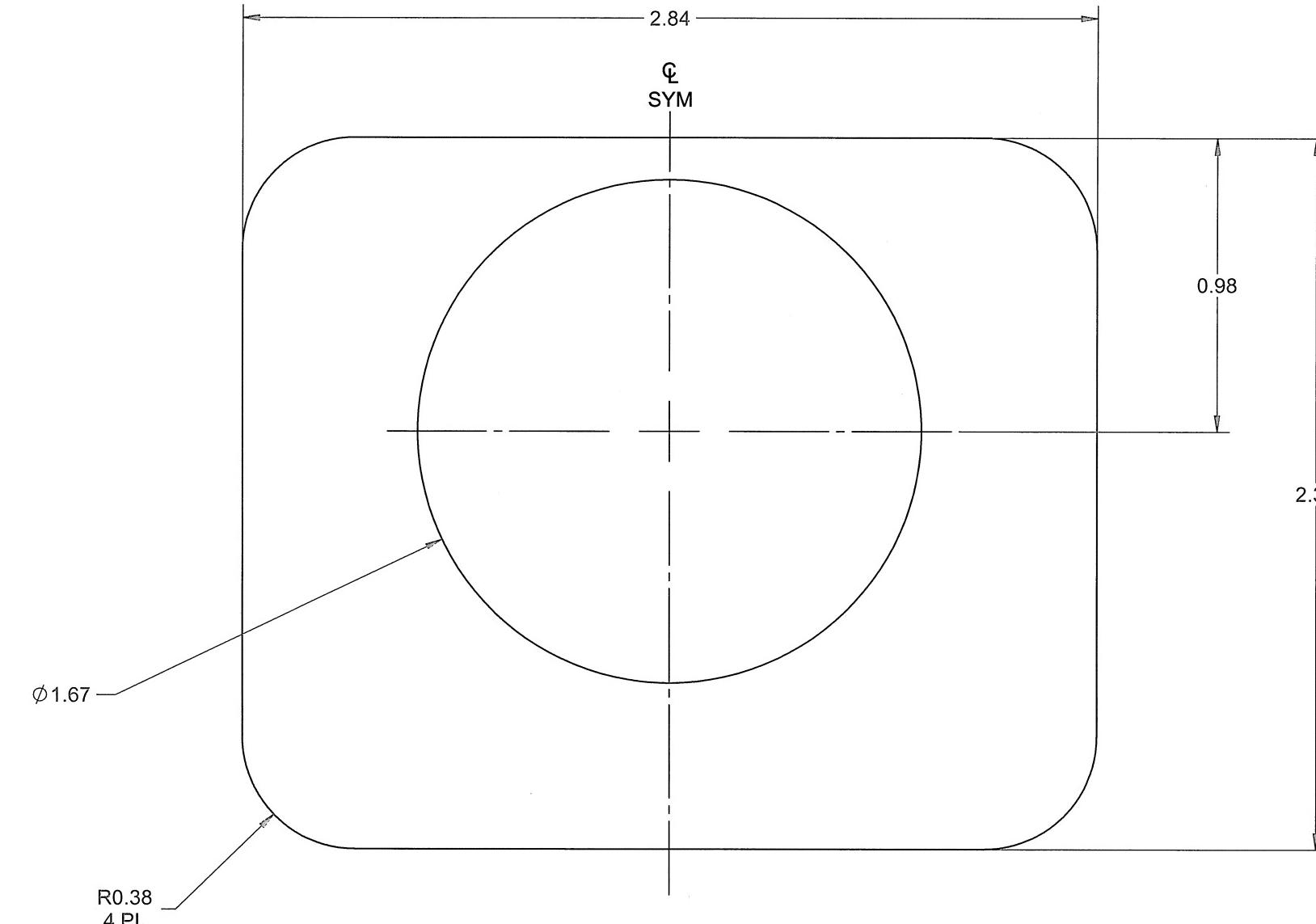
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RBW6700G04231-6F-3 PLATE PROTECTION

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NOTES:

- 1) MATERIAL: McMaster#8569K26 OR EQUIV (TEFLON PTFE SHEET 6" WIDE X 0.04" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.010" PER CAD FILE RBW6700G04231-6F-3 REV. A.DXF

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	VM		
DATE 4/2/2019		REV. A	
TOOL PART # RBW6700G04231-6F		SHEET 4 OF 9	
TITLE UPPER PLATE ASSY		SCALE NTS	

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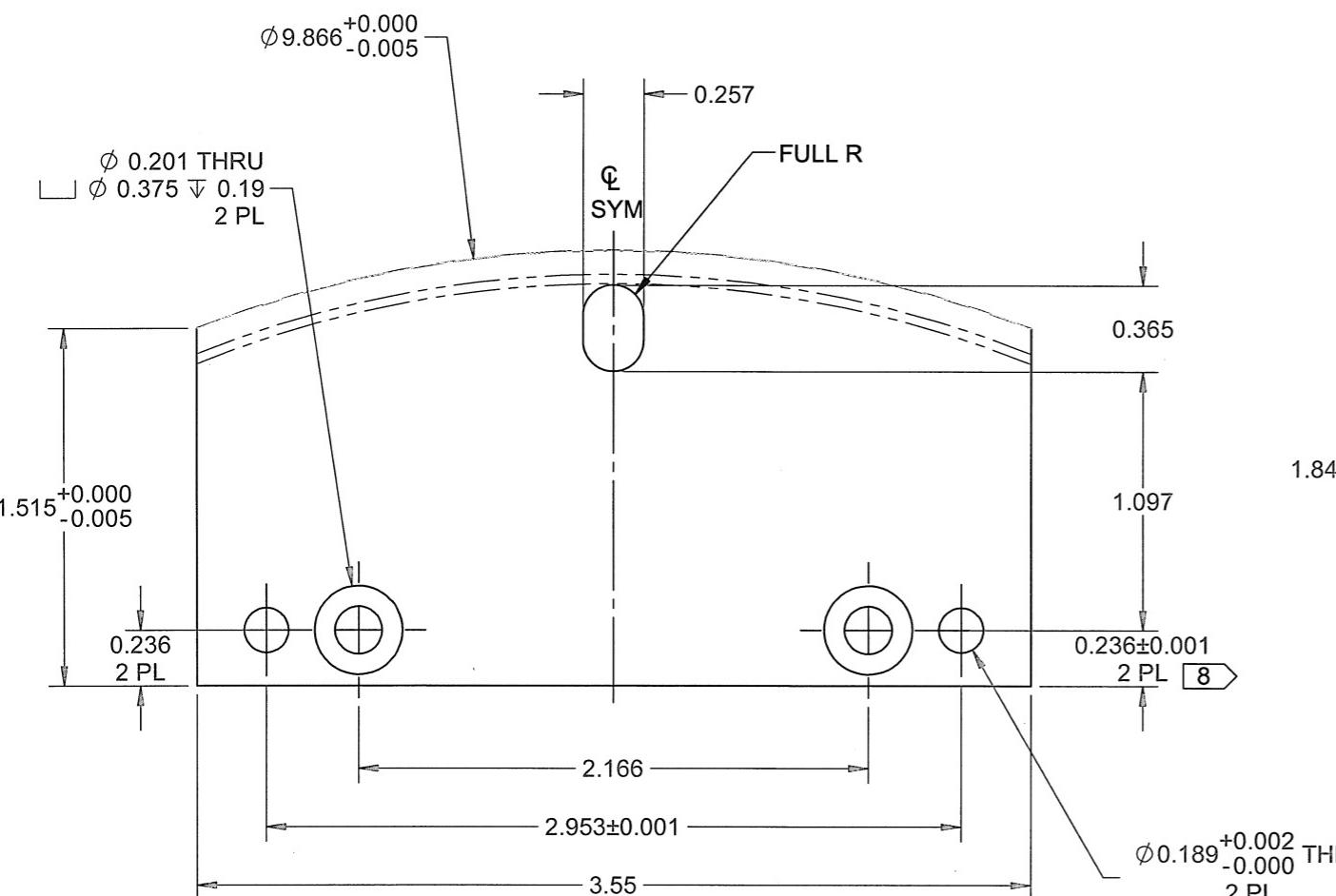
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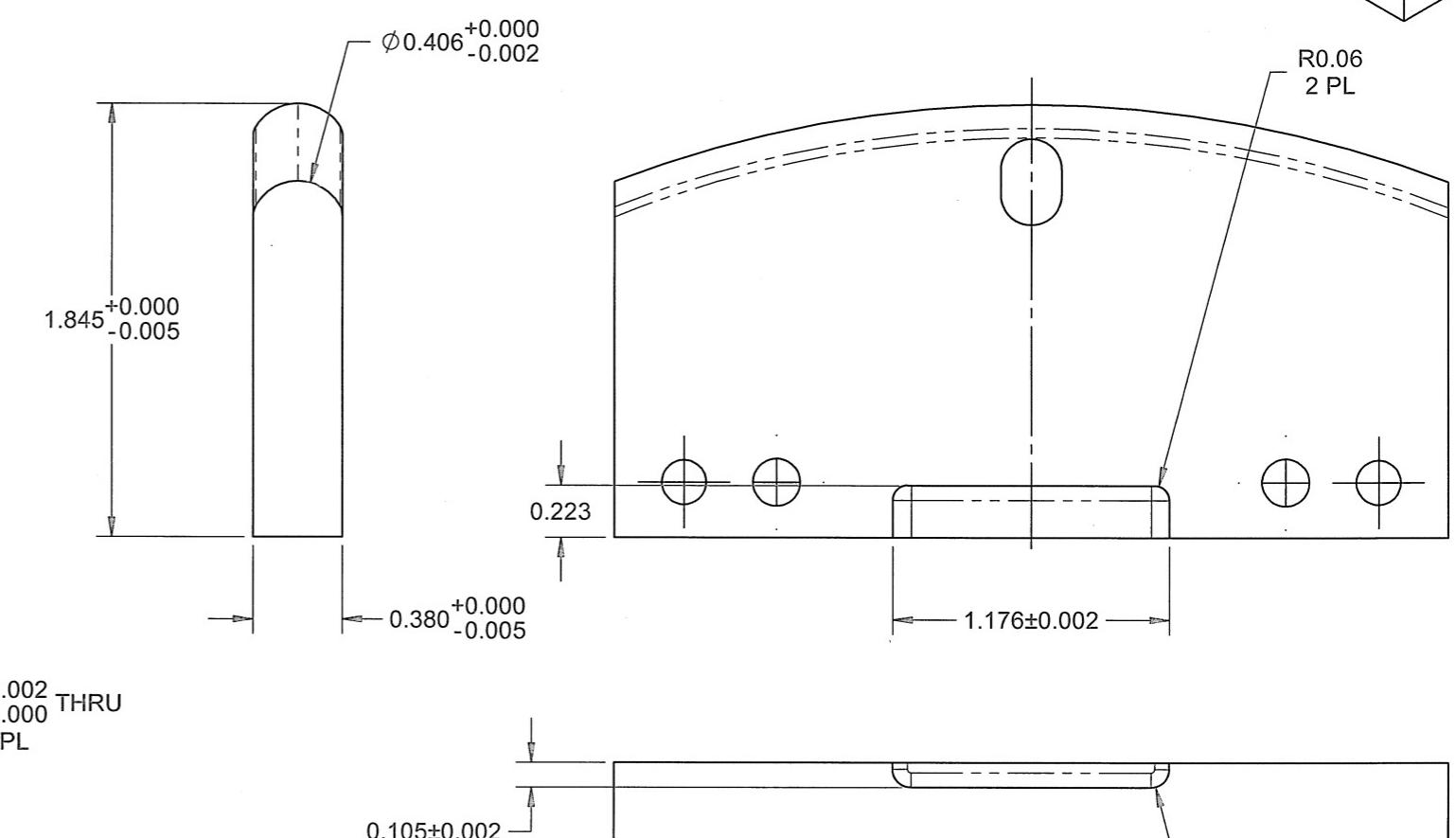


RBW6700G04231-6F-4 BRONZE PLATE

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NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSION ONLY APPLICABLE FOR DOWEL PIN HOLES OF HOLES OF Ø 0.189 +0.002/-0
- 9) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.005" PER CAD FILE RBW6700G04231-6F-4 REV. A.STEP



DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6700G04231-6F
APPROVED	VR	TITLE
DATE 4/2/2019		UPPER PLATE ASSY
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REV. A
SHEET 5 OF 9SCALE
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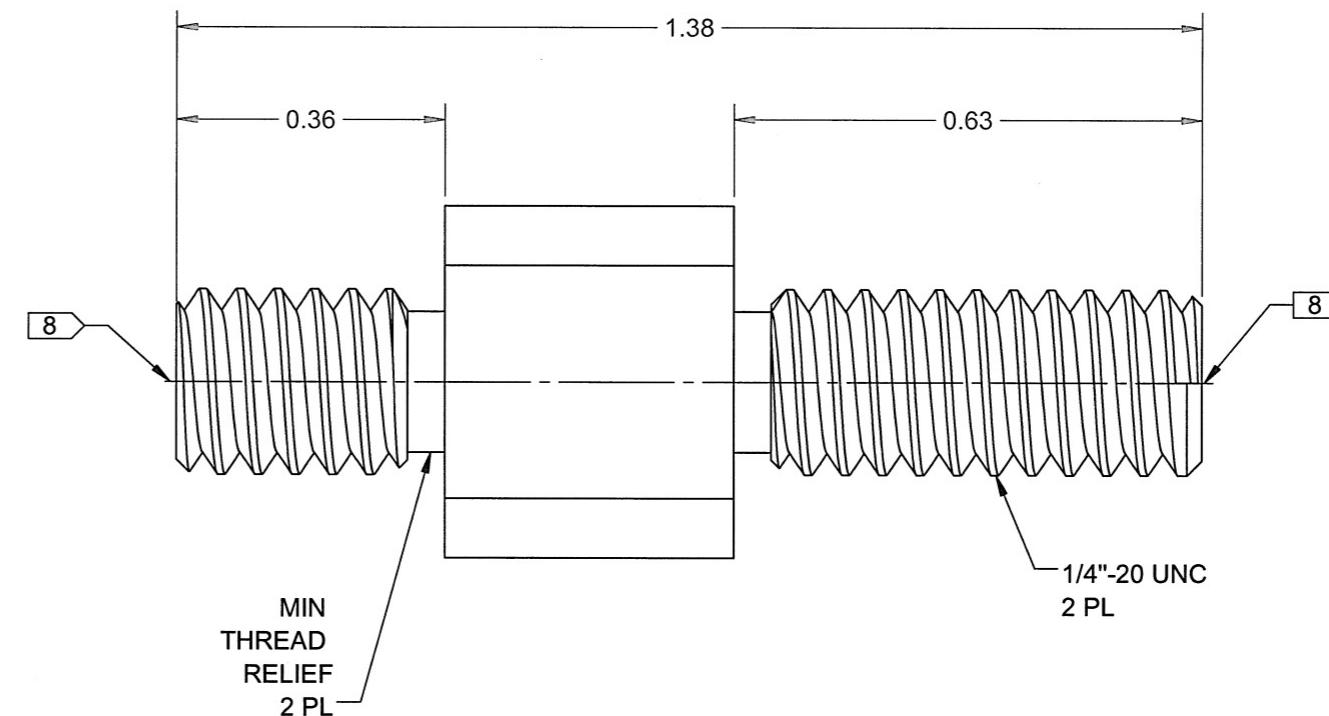
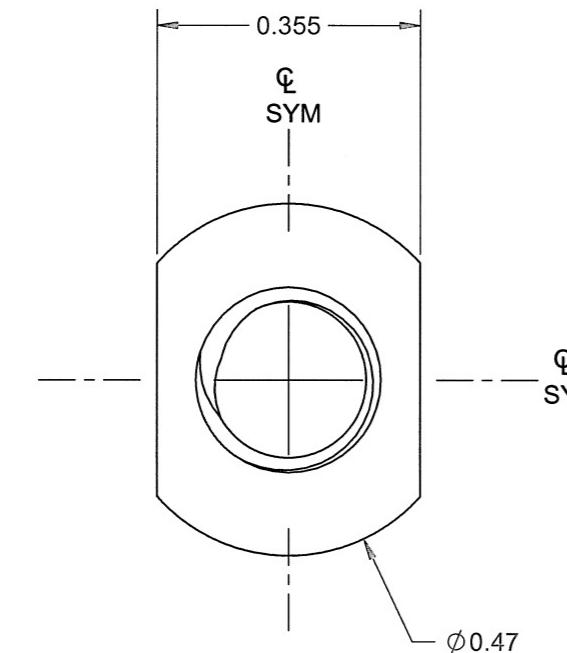
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RBW6700G04231-6F-5 SHAFT

NOTES:

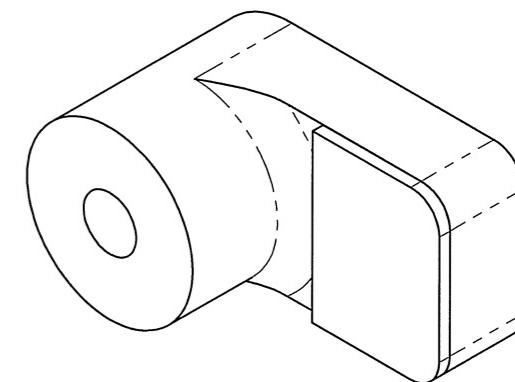
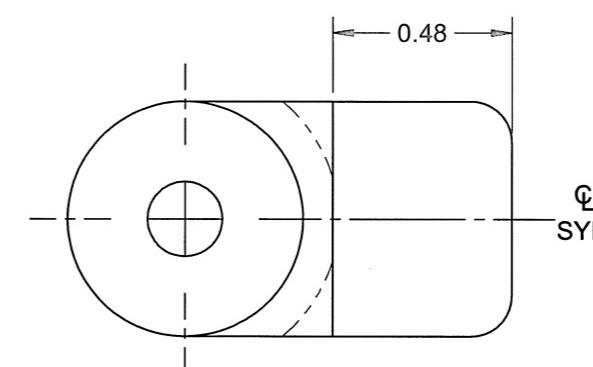
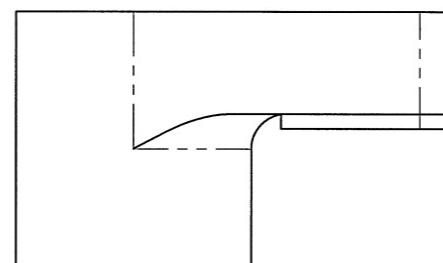
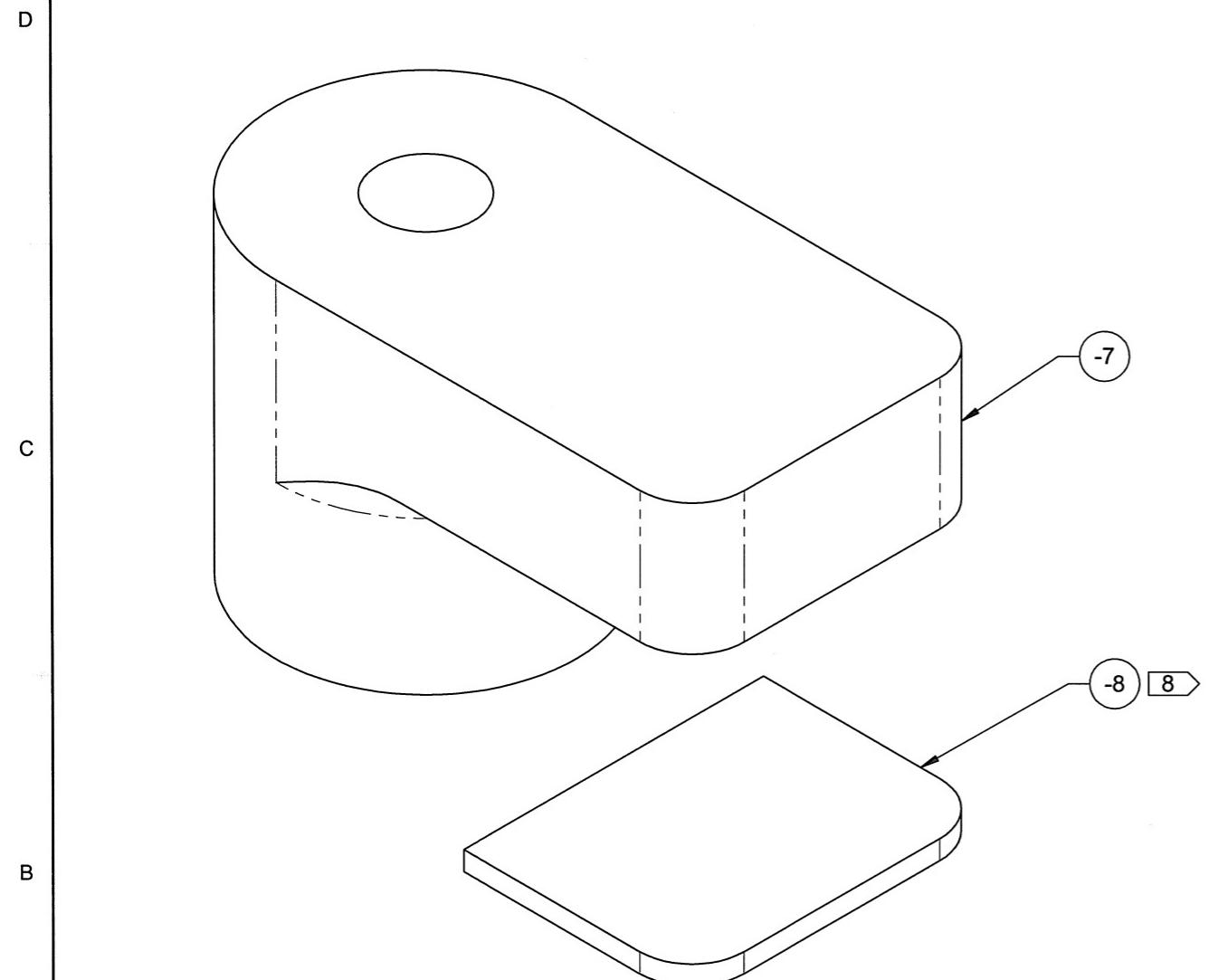
- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6700G04231-6F
APPROVED	WP	TITLE
DATE	4/2/2019	UPPER PLATE ASSY

REV. A
SHEET 6 OF 9
SCALE NTS
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ITEM #	QTY	PART #	PART TITLE
-7	1	RBW6700G04231-6F-7	STOPPER
-8	1	RBW6700G04231-6F-8	STOPPER PROTECTION

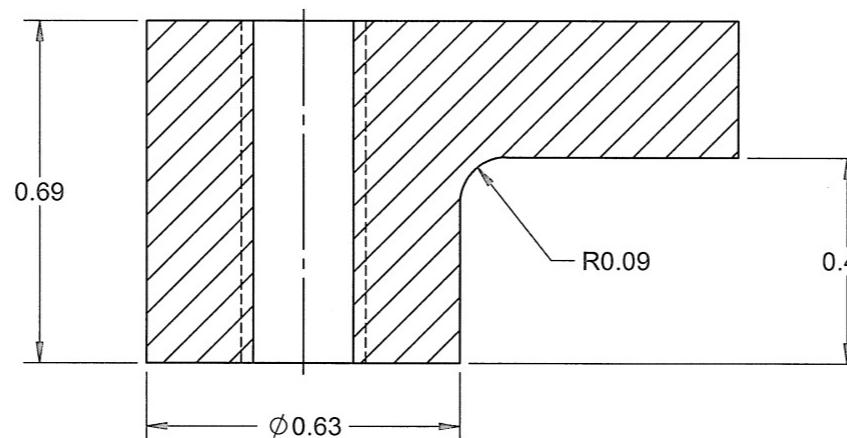
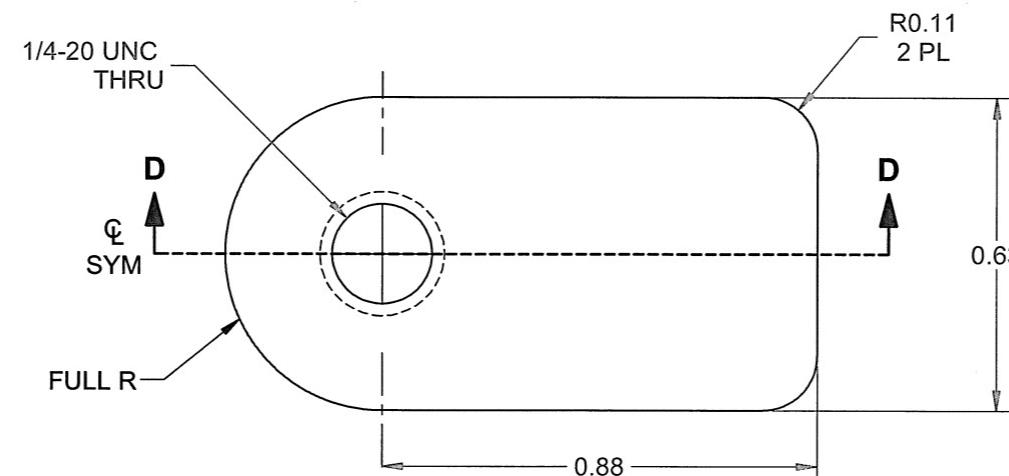


RBW6700G04231-6F-6 STOPPER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES OF ITEM -7 AND ITEM -8, REMOVE EXCESS, AND CUT EXCESS IF NECESSARY

DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	KPT	REV. A	
APPROVED	FK	SHEET 7 OF 9	
DATE 4/2/2019		TOOL PART #	RBW6700G04231-6F
		TITLE	UPPER PLATE ASSY
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RBW6700G04231-6F-7 STOPPER

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6700G04231-6F
APPROVED	VJL	TITLE
		SCALE
		NTS
DATE 4/2/2019		

REV. A
SHEET 8 OF 9
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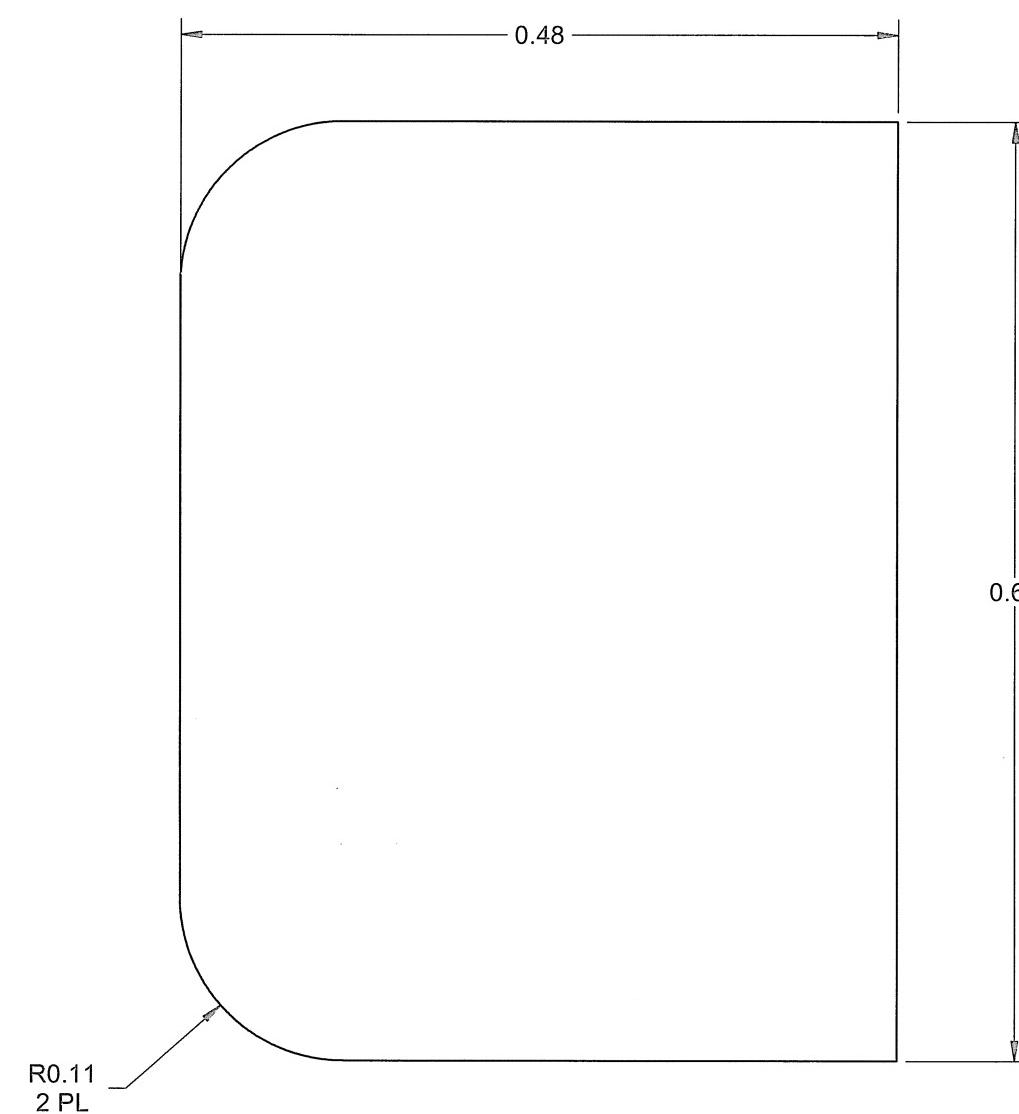
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RBW6700G04231-6F-8 STOPPER PROTECTION

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NOTES:

- 1) MATERIAL: McMaster#8569K26 OR EQUIV (TEFLON PTFE SHEET 6" WIDE X 0.04" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ALL NON-DIMENSIONED FEATURES MUST MAINTAIN A TOLERANCE OF +/- 0.010" PER CAD FILE RBW6700G04231-6F-8 REV. A.DXF

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	VIP		
DATE 4/2/2019		TOOL PART # RBW6700G04231-6F	
		TITLE UPPER PLATE ASSY	
		SCALE NTS	
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